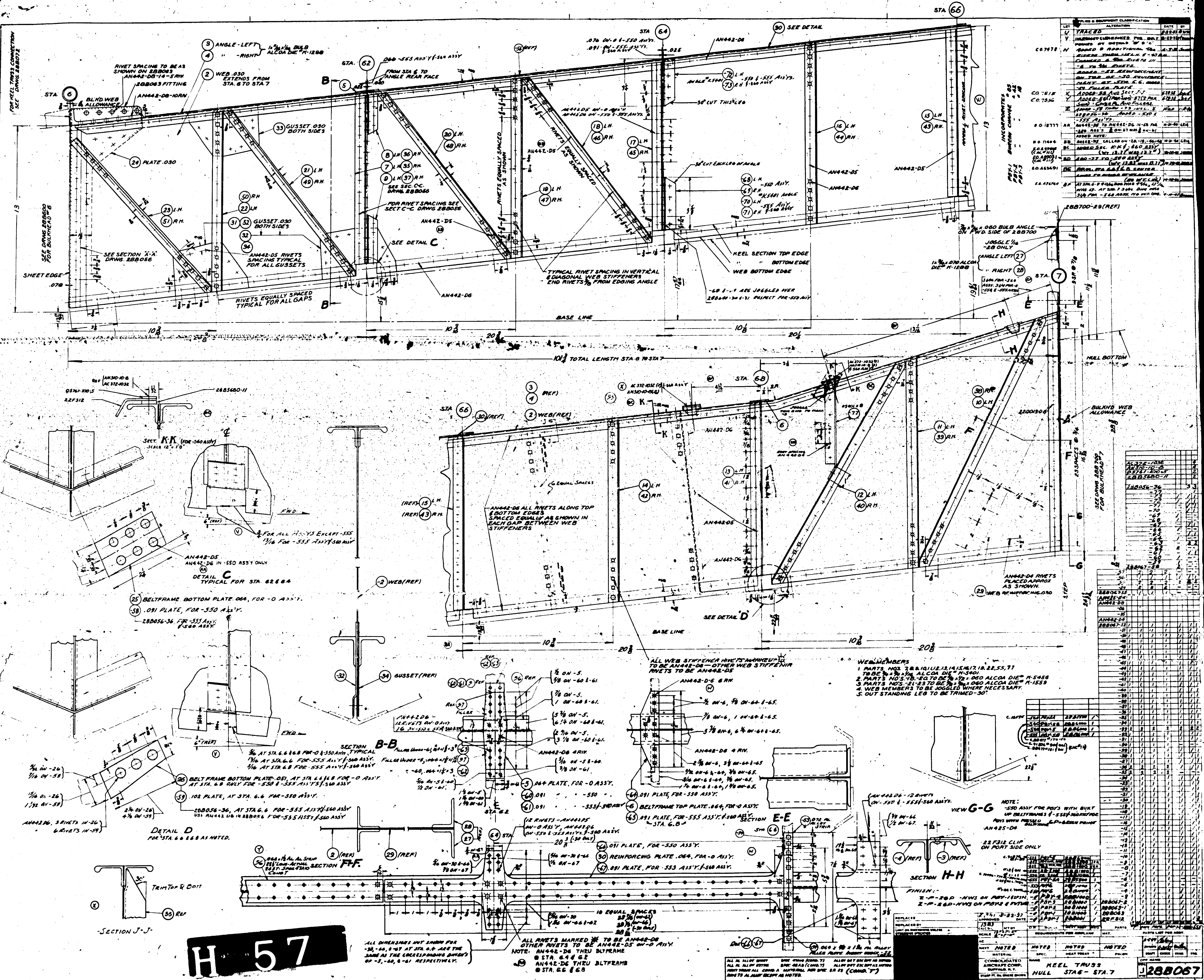


STA. 66
FOR KEEL TRUSS CONNECTION SEE DRWG 2BB072
STA. 6
BLK'HD WEB ALLOWANCE
RIVET SPACING TO BE AS SHOWN ON 2BB063
AN442-D8-14-5 RW
2BB063 FITTING
AN442-D8-10RN
ANGLE - LEFT
" - RIGHT
ALCOA DIE K-1288
WEB .030 EXTENDS FROM STA. 6 TO STA. 7
STA. 62
FROM STA 6 TO ANGLE REAR FACE
SEE DETAIL
AN442-D6
AN442-D5
GUSSET .030 BOTH SIDES
PLATE .030
SEE DRWG 2BB600 FOR BULKHEAD 6
SEE SECTION 'A-A' DRWG. 2BB056
AN442-D5 RIVETS SPACING TYPICAL FOR ALL GUSSETS
SHEET EDGE
RIVETS EQUALLY SPACED TYPICAL FOR ALL GAPS
FOR RIVET SPACING SEE SECT C-C DRWG 2BB056
SEE SEC. C-C DRWG. 2BB056
SEE DETAIL C
RIVETS EQUALLY SPACED AS SHOWN
TYPICAL RIVET SPACING IN VERTICAL & DIAGONAL WEB STIFFENERS END RIVETS 3/16 FROM EDGING ANGLE
30° CUT THIS LEG
30° CUT EACH LEG OF ANGLE
KEEL SECTION TOP EDGE
BOTTOM EDGE
WEB BOTTOM EDGE
2BB700-29 (REF)
JOGGLE 1/16 -28 ONLY
ANGLE LEFT
RIGHT
STA. 7
BASE LINE
TOTAL LENGTH STA. 6 TO STA. 7
HULL BOTTOM
BULKHD WEB ALLOWANCE
SEE DRWG 2BB700 FOR BULKHEAD 7
23 SPACES
SECT. K-K (FOR -560 ASSY) SCALE 12" = 1'0"
2BB5680-11
22F312
FWD
FOR ALL ASSYS EXCEPT -555
13/16 FOR -555 ASSY & -560 ASSY
AN442-D5
AN442-D6 IN -550 ASS'Y ONLY
DETAIL C TYPICAL FOR STA. 62 & 64
BELTFRAME BOTTOM PLATE .064, FOR -0 ASS'Y.
.091 PLATE, FOR -550 ASS'Y.
2BB056-36 FOR -555 ASSY & -560 ASSY
WEB (REF)
AN442-D6 ALL RIVETS ALONG TOP & BOTTOM EDGES SPACED EQUALLY AS SHOWN IN EACH GAP BETWEEN WEB STIFFENERS
6 EQUAL SPACES
AN442-D4 RIVETS PLACED APPROX AS SHOWN
WEB REINFORCING .050
SEE DETAIL 'D'
STEP
ALL WEB STIFFENER RIVETS MARKED TO BE AN442-D6 - OTHER WEB STIFFENER RIVETS TO BE AN442-D5
WEB MEMBERS
1. PARTS NOS. 7,8,&10,11,12,13,14,15,16,17,18,22,55,77 TO BE 3/4 x 3/4 x 1/16 ALCOA DIE K-5401
2. PARTS NOS. 19-20 TO BE 3/4 x 1/2 x .060 ALCOA DIE K-5456
3. PARTS NOS. 21-23 TO BE 3/4 x 3/4 x .060 ALCOA DIE K-1559
4. WEB MEMBERS TO BE JOGGLED WHERE NECESSARY.
5. OUT STANDING LEG TO BE TRIMMED-30°
GUSSET (REF)
SECTION B-B TYPICAL
BELT FRAME BOTTOM PLATE .051, AT STA. 6.6 & 6.8 FOR -0 ASS'Y. AT STA. 6.8 ONLY FOR -550 & -555 ASS'Y & -560 ASSY
.102 PLATE, AT STA. 6.6 FOR -550 ASS'Y.
2BB056-36, AT STA 6.6 FOR -555 ASSY & -560 ASSY
DETAIL D FOR STA 6.6 & 6.8 AS NOTED.
.064 PLATE, FOR -0 ASSY.
.091 PLATE, FOR -550 ASS'Y.
BELTFRAME TOP PLATE .064, FOR -0 ASSY.
.091 PLATE, FOR -555 ASS'Y & -560 ASSY
SECTION E-E
VIEW G-G
NOTE: -550 ASSY FOR PBY3 WITH BUKT UP BELTFRAMES
AN425-D4
22F312 CLIP ON PORT SIDE ONLY
SECTION H-H
SECTION F-F
.091 PLATE, FOR -550 ASS'Y.
REINFORCING PLATE .064, FOR -0 ASSY.
.091 PLATE, FOR -555 ASS'Y & -560 ASSY
10 EQUAL SPACES
TRIM TOP & BOTT
SECTION J-J
FINISH:
H 57
ALL DIMENSIONS NOT SHOWN FOR -36, -60, & -67 AT STA. 6.6 ARE THE SAME AS THE CORRESPONDING DIMEN'S OF -5, -60, & -61 RESPECTIVELY.
ALL RIVETS MARKED TO BE AN442-D6 OTHER RIVETS TO BE AN442-D5 ON -0 ASSY.
NOTE: AN442-D6 THRU BLTFRAME @ STA. 6.4 & 6.2
AN442-D6 THRU BLTFRAME @ STA. 6.6 & 6.8
CONSOLIDATED AIRCRAFT CORP. BUFFALO, N.Y.
[redacted]
KEEL TRUSS
HULL STA 6 - STA 7
2BB067